



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7701

Job Sheet 186271

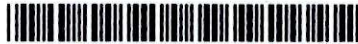


DAS
21
0-05

Part No: 647.7701

Job Qty: 4 ea

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A2 IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/14/18	0.00	0.00	Start Up Large Fab-1		DYC 18-11-28
110	Packaging	4 pcs		12/14/18	0.00	0.00	Packaging1-1		DYC 18-11-28
120	Large Fab	4 pcs		12/14/18	0.00	1.75	Large Fab 4		DYC 18-11-28
130	QC	4 pcs		12/14/18	0.00	0.00	QC9		EL
140	QC	4 pcs		12/14/18	0.00	0.00	QC5		EL
150	Outsource	4 pcs		12/14/18			GRO002-VC	10	
160	Packaging	4 pcs		12/14/18	0.00	0.00	Packaging2		DEC 05 2018
170	QC	4 pcs		12/14/18	0.00	0.00	QC5		DEC 06 2018
180	SprayPaint	4 pcs		12/14/18	0.00	0.32	Spray Paint		AB 18-12-7
190	QC	4 pcs		12/14/18	0.00	0.00	QC14		
200	Packaging	4 pcs		12/14/18	0.00	0.00	Packaging3-1		DEC 13 2018
210	QC21-SA	4 Ea		12/14/18	0.00	0.00	QC21		DEC 17 2018

Part Op 120 - 1- ASSEMBLE AND WELD AS PER DWG ***IMPORTANT DIMENSION IS 23.75" ***

Descriptions: 150 - Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread

180 - PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG PRIMER BATCH: 5094268

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.7710	Strut Tube	4 Ea (1 ea)	90-Start up Operation	5131842
647.7712	Strut Tube	4 Ea (1 ea)	90-Start up Operation	5127899
647.7713	Strut Thread	4 Ea (1 ea)	90-Start up Operation	5127373

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	647.7710	4	6	0
	647.7712	4	21	0
	647.7713	4	40	0

Part Specifications

Specifications could not be found.

P.T.O.

DQA: _____ Date: _____



WORK ORDER-NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
NCR No. _____	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Disposition

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

**QC / QA Coordinator
Approval**

FAULT CATEGORY

fect

ate/Unqualified

Power Loss/Surge

Folio/Program

Grain

Weld

Positioned, Wrong

Outside Dimensions

Over/Under tolerance

Part incorrect.

112/10 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5209
Email: sales@dataero.com
www.dataerospace.com

Date: 11/28/18

DAKI
AEROSPACE

Container No: S132792

Part: 647.7701

Job No: 186271

Serial No/Batch: S132792

Revision:

Inspector:
Exp Date:

Instructions:

material	Use for Testing	Cutts	Contamination
Internal Transport	Poor Information	Crushing	Countersink
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete
Substation	Process Improvement	Marks/Chatter	Drill Holes
Past Expiry Date	Manufacturing Process		
Misidentified	Past Due	OTHER :	

Uart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S132792
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041910**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041910
PO Date: 11/30/18
Due Date: 12/7/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments: ** is it possible to get htis for Dec. 5 **

Please confirm

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186271	647.7701	Strut Assembly Issue P/O _____ Group Altech CAD PLATE IAW QQ-P- 416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	-	12/7/18	10 pcs	0 pcs	10 pcs	\$17.50/pcs	\$175.00
Grand Total:											\$175.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/30/18 3:23 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014963- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
04-Dec-2018		Ross Montieth		041910				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	647.7701 Rev.	647.7701 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE 2 CAD PLATE SHOULD NOT BE TO THICK AROUND TREAD	CADMIUM CH	10	10	0	0	0

DAS
68
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: <u>186271</u> Part No. <u>647.7701</u> NCR No. <u>16-5871</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☒</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒	Large Fab ☐	Composite ☐	Supplier ☐																																																					
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Date: <u>DEC 06 2018</u>		Step #: <u>170</u>		QTY Effective: <u>10</u>		MRB (QSI042) Approval <u>PD 9-89 18-12-06</u>																																																																					
Description Work Order Deviation <u>- PARTS AFTER CAD PLATING ON THREADS ARE TOO TIGHT. GO-GAGE REMOVES PLATING IN AREAS.</u> <u>- SEE NCR16-5871</u>				Disposition <u>Parts are acceptable as is</u> <u>PO to be update to reflect changes on NCR16-5871 and limit plating to .003"</u>				Completed By <u>PD 19-05-07</u>																																																																			
				Lead hand / Supervisor Approval Verification <u>DAS 9-89 18-12-06</u>																																																																							
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Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Thursday, December 06, 2018

Details			
Raised Date 6/30/2016	Status Closed	Owner Maranda, Denis	Number NCR16-5871
Target Date 7/31/2016	Standard		Severity
Process		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) Purchasing	Fault Category General\Instructions Incomplete/Unclear	
Details found at inspection that cad plate on PO 32713 647.7701 B146722 was too thick which prevent us to install clevis. Same issue where found on 647.7703 B145013 & 647.7702 B146723			
Keywords		Product 647.7701	
Document		Root Cause	
Closed By Downing, Eric M	Closed Date 7/14/2016	Resolution	

Corrective Action			
Target Date 7/11/2016	Owner Lacelle, Linda	Closed Date 7/14/2016	Closed By Downing, Eric M
Details PO has been amended to call class 3 cad on threaded area only			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Lacelle, Linda	7/11/2016	7/14/2016
make note on futur PO to limite cad platting on threads to .003" or less		Change on PO and routing by Linda see attached email for proof of changmet	

Verification & Review			
Target Date 7/12/2016	Owner Downing, Eric M	Closed Date 7/14/2016	Closed By Downing, Eric M
Details all actions complete			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	